



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.2511
Job Sheet 169877



Part No: 647.2511

Job Qty: 10 ea

Part Name: Nut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: Stock

Description:

Customer: Metro Aviation Inc (CMETRO1)

PO Box 7008 Shreveport, LA, 71137 USA ph:(318) 222-5529 fx:(318) 698-5205.

Note: DWG REV A IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/11/18	1/11/18	0.00	0.00	Start Up Machining-1		MSP 18/01/08
100	Doosan	10 pcs	1/12/18	1/12/18	0.00	4.76	Doosan		MSP 18/01/08
110	QC	10 pcs	1/12/18	1/12/18	0.00	0.00	QC2 Machining-1		MSP 18/01/08
140	QC	10 pcs	1/12/18	1/12/18	0.00	0.00	QC8 Machining-1		FR 18-1-9
150	Purchasing	10 pcs	1/12/18	1/12/18	0.00	0.00	Purchasing		AT 18/02/05
160	Packaging	10 pcs	1/12/18	1/12/18	0.00	0.00	Packaging2		AT 18/02/05
170	QC	10 pcs	1/12/18	1/12/18	0.00	0.00	QC5		38
180	Packaging	10 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3-1		2-89 DAS 21
190	QC21-SA	10 Ea	1/12/18	1/12/18	0.00	0.00	QC21		21

Part Op 100 - 1- Turn as per Folio FB144 AND DWG DWG Rev: ____ FOLIO Rev: ____ -Deburr per dwg ***CHECK NEEDS
Descriptions: USING GO/ NO GO GAUGE*****

140 - 100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT

150 - Issue P/O: 38767 Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required

160 - Ensure certificate of conformity is attached

JAN 11 2018

DAS
13
9-89

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M17-4-H1150-R1.000	1	8	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Nut	0.875Inches ± 0.010	0.874 0.885 0.865		
2	Nut	0.530Inches ± 0.010	0.520 0.540 0.520		
3	Nut	90.000Degrees ± 0.500	90° 90.500 89.500	Angle	
4	Nut	0.660Inches ± 0.010	0.653 0.670 0.650		
5	Nut	0.130Inches ± 0.010	0.128 0.140 0.120		

6	Nut	0.580Inches ± 0.002	0.5795	0.582 0.578
7	Nut	0.590Inches ± 0.010	0.590	0.600 0.580

Plex 1/3/18 8:09 AM dart.poulin.mario

DART
AEROSPACE
S030171

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Nut

PART NO: 647.2511

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 01/08/18

Job No: 169877



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038767**

E-MAILED
JAN 15 2018

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO038767

PO Date: 1/11/18

Due Date: 1/22/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	169386	647.7701	Strut Assembly Issue P/O : _____ Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread	Firmed	1/22/18	10 pcs	0 pcs	10 pcs	\$6.00/pcs	\$60.00
						✓ 10x			AT 18/02/05	
2	169387	647.7702	Strut Assembly Issue P/O : _____ Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread	Firmed	1/22/18	10 pcs	0 pcs	10 pcs	\$6.00/pcs	\$60.00
						✓ 10x			AT 18/02/05	
3	169877	647.2511	Nut Issue P/O: _____ Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required	Firmed	1/22/18	10 pcs	0 pcs	10 pcs	\$2.3809523/pcs	\$23.81
						✓ 10x			AT 18/02/05	
4	169400	647.8511	Insert -Issue P/O to Groupe Altech: P/O -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed	1/22/18	11 pcs	0 pcs	11 pcs	\$2.3809523/pcs	\$26.19
						✓ 11x			AT 18/02/05	
5	169401	647.8512	Insert -Issue P/O to Groupe Altech: P/O -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed	1/22/18	21 pcs	0 pcs	21 pcs	\$2.3809523/pcs	\$50.00
						✓ 21x			AT 18/02/05	

PURCHASE ORDER

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	169271	RB	Jack Screw	Firmed	1/22/18	3 pcs	0 pcs	3 pcs	\$30.00/pcs	\$90.00
		T101338-3	-Issue P/O to Groupe Altech: P/O							
			-Zinc plate, ASTM B633 TYPE 1							
			SC2							
			-Certificate of Conformity is required							
									Grand Total:	\$310.00
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 1/15/18 11:04 AM dart.lavoie.chantal



Certificat de Conformité / Certificate of Compliance

(005811-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

005811- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courtier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
22-Jan-2018		Curtis Anderson		PO038767				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	647-7701 Rev.	647-7701 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE 2 CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD	CADMIUM CH	10	10	0	0	0
2	647-7702 Rev.	647-7702 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE 2 CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD	CADMIUM CH	10	10	0	0	0
3	647-2511 Rev.	647-2511 PASSIVATION AS PER MIL-S-5002 TYPE 6	PASSIVATION CH	10	10	0	0	0
4	647-8511 Rev.	647-8511 PASSIVATION MIL-S-5002 TYPE 6	PASSIVATION CH	11	11	0	0	0
5	647-8512 Rev.	647-8512 PASSIVATION MIL-S-5002 TYPE 6	PASSIVATION CH	21	21	0	0	0
6	RBT101338-3 Rev.	RBT101338-3 ZINC PLATE ,ASTM B633 TYPE 1 SC2	ZINC CH	3	3	0	0	0

Notes Additionnelles / Additional Notes

CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements
 Our financial and legal responsibility will not be higher than the amount of invoice.